

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020443**Date Inspected:** 09-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Yin chun feng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Traveler Rails and Handrails**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 20TR2-051-017,located on Traveler Rail, identified 20TR2-051, welding miscellaneous gouges and repair (undercut & knicks from cutting touch) no weld number, welder is identified as 045269, ZPMC Quality Control (QC) is identified as Mr.Yin chun feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G-(2F)-repair-1.

SMAW welding of Hand Rail identified SB6, welder is identified as 067752, ZPMC Quality Control (QC) is identified as Mr.Mai quin li. The welding variables recorded by QC appeared to comply with WPS-B-T-2212-ESAB.

This QA Inspector observed insufficient throat in flare bevel groove weld between the grating post to handrail tube steel post on handrails 05, 13,18, per Sheet SB6-08, detail H-H. Talked to ZMPC QC. Shazhi and Ma qian li about the insufficient throat on the Service Platform Handrail, (SP5 & SP6), they said they would look into it, that there was some concern about weld distortion.

WELDING INSPECTION REPORT

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OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

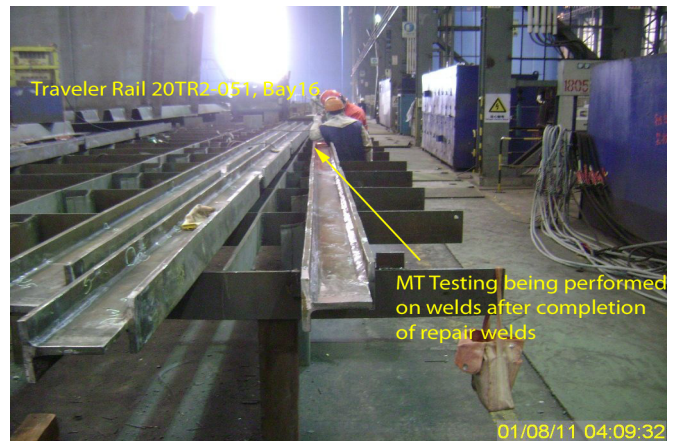
FCAW welding of weld joint SA3400A-009-002, located on Splice Plate, identified as SA3400A-009, welder is identified as 059416, ZPMC Quality Control (QC) is identified as Yang Bai Qiany. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3400A-001-002, located on Splice Plate, identified as SA3400A-001, welder is identified as 059378, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiany. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3400A-001-001, located on Splice Plate, identified as SA3400A-001, welder is identified as 203805, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiany. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA inspector performed VT testing on 100% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. Time of inspection was 14:00 hours. The members are identified as follows OBG, Service Platform, The weld designations reviewed are as follow: SP7-07, SP7-08-001,002, S(8-07, SP8-08-001, 002, SP4-07, SP4-08-001,002,

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Talked to ZMPC QC. Shazhi and Ma qian li about the insufficient throat on the Service Platform Handrail, (SP5 & SP6), they said they would look into it, that there was some concern about weld distortion.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
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Reviewed By:	Hall, Steven	QA Reviewer
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